

SHH 16/01

Dart Aerospace Ltd.

3

Date: Monday, 1/7/2008 11:35:17 AM
User: Kim Johnston

Process Sheet

Spld-25
00615

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHORT STEP ASSEMBLY
Job Number	: 36602 -2		
Estimate Number	: 11999		
P.O. Number	: N/A	Part Number	: D350591122
This Issue	: 1/7/2008	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2351 UNDER REVIEW
First Issue	: N/A	Project Number	: N/A
Previous Run	: 36239	Drawing Revision	: E
Written By	: [Signature]	Material	: N/A
Checked & Approved By	: [Signature] 08.01.07	Due Date	: 1/16/2008
Comment	: Est Rev: E 02.10.21 Re-format; Incorporated D2351-041 IPP K J/RF		

Qty: 5 Um: 5 Eac
POSITIVE RECALL

Additional Product		
Job Number: [Barcode]		
Seq. #:	Machine Or Operation:	Description:
1.0	DC	DOCUMENT CONTROL
	[Barcode]	[Barcode]
Comment: DOCUMENT CONTROL Photocopy bluefile and type labels as per PPP D350-591-122 CHG003		
2.0	D2244116	Step Extrusion
	[Barcode]	[Barcode]
Comment: Qty.: 0.5000 Each(s)/Unit Total: 2.5000 Each(s) Pick: Qty Part Number Description Batch 0.5 D2244-116 Extrusion B33733		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	[Barcode]	[Barcode]
Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2244-128 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G 2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.		
4.0	QC5	INSPECT WORK TO CURRENT STEP
	[Barcode]	[Barcode]
Comment: INSPECT WORK TO CURRENT STEP		
5.0	BENDING	BENDING MACHINE
	[Barcode]	[Barcode]
Comment: BENDING MACHINE Bend as per dwg		

SAD 08/01/09
08/01/10 (45)
F2 8-1-10

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 36602

Part Number: D350591122

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/10 (28)

7.0

D28502

End Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2850-2 End Bracket 329849

08.01.11

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Fwd and Aft end for welding

2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033

A/R Aluminum Rod 1105844

3-Do not Grind Flush

08.01.14
08.01.14
SAD 08.01.15

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-01-15 (8)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/15 (42)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 08-01-15 (2)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

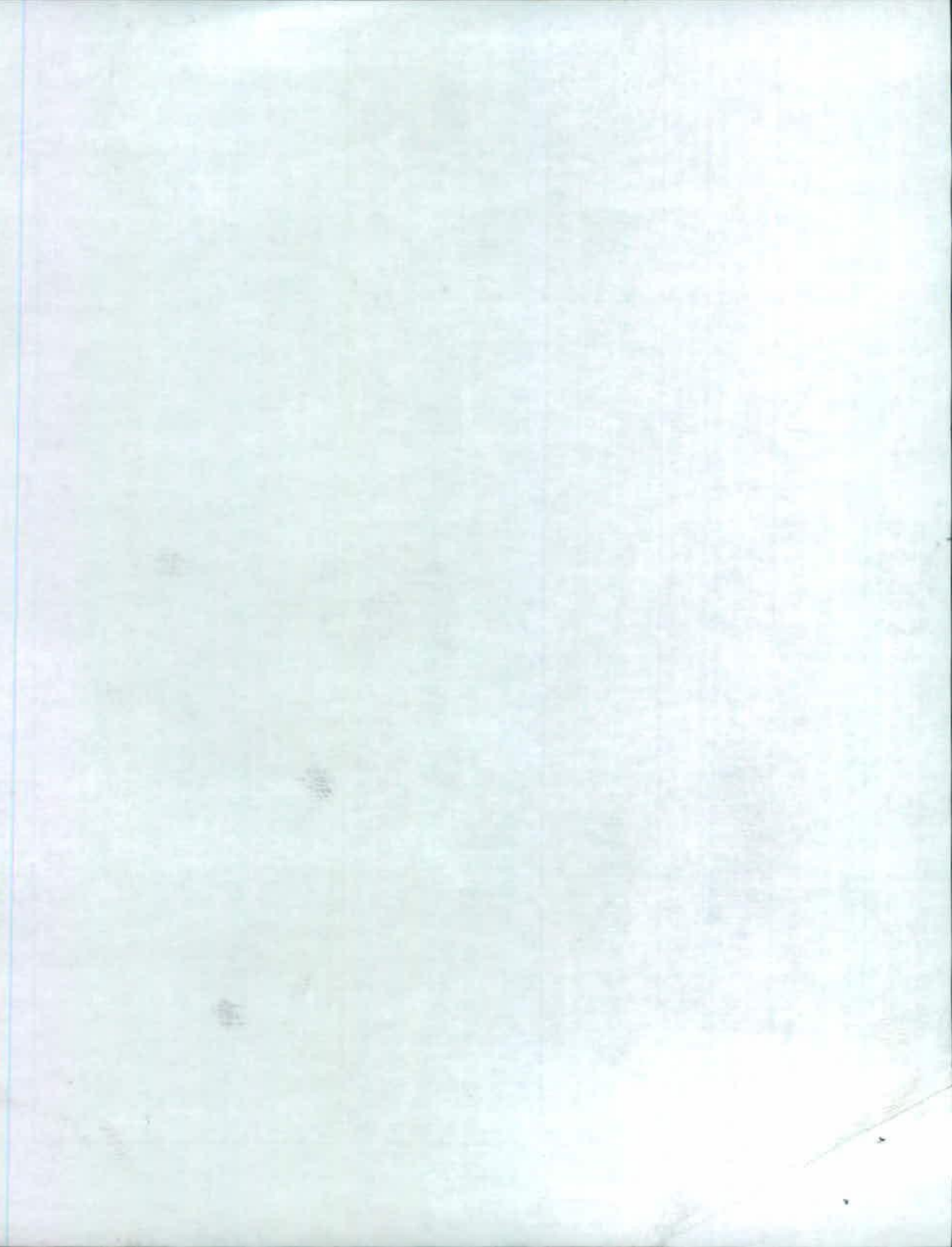


Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/01/15 (2x)

Handwritten notes in the top left corner, possibly including a date or reference number.

Handwritten text in the top center, possibly a title or subject line.



Date: Monday, 1/7/2008 11:35:17 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 36602

Part Number: D350591122

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D2582

Hi-Skid Step Leg Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2582

Step Leg Assy

336710

POSITIVE RECALL

EFFECTIVE 03.01.02 AUTH R#

RELEASED 4 DATE 08.01.15

14.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W3

Rivet

M104715

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Rivet Leg Assembly as per Dwg D2351

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

D267334

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2673-34 End Plate

329356

25396

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd End Plate per QSI 004 & Dwg D2351

A/R

Aluminum Rod

M105058

2-Grind end plate flush.

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 36602

Part Number: D350591122

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/01/16 (2)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-01-16 (2)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

m-l

08/01/16

(2X)

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 106379

m-l 08/01/16

(2X)

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk per Dwg D2351 and QSI 005 4.4

Batch: m106332

BR/FL

08/01/16 (2)

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/01/16 (2)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

D22301

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Packing KitQtyPart Number

Description

Batch

1 D2230-1 Mounting Lug

30/55 (X)

32250 (1X)

8/1/16

(2X)

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Drawing Name: SHORT STEP ASSEMBLY

Job Number: 36602

Part Number: D350591122

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D22303

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Packing KitQtyPart Number Description Batch

1 D2230-3 Mounting Lug 35800

28.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total: 3.0000 f(s)

Pick:

Packing KitQtyPart Number Description Batch

1 D2856-400 7.20" Abrasion Strip 35900

29.0

AN337A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Packing KitQtyPart Number Description Batch

2 AN3-37A Bolt 4104016

30.0

AN413A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Pick:

Packing KitQtyPart Number Description Batch

3 AN4-13a Bolt 4106513

31.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Packing KitQtyPart Number Description Batch

4 AN960JD10 Washer 4106167 (7x) 4105792 (1x)

32.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Packing KitQtyPart Number Description Batch

6 AN960JD416 Washer 4105906 8/1/16 (2x)

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Job Number: 36602

Part Number: D350591122

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Packing KitQtyPart Number Description Batch

2 MS21042L3

Nut (or -3)

4105558

CU

34.0

MS21042L4

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Pick:

Packing KitQtyPart Number Description Batch

3 MS21042L4

Nut (or -4)

4105054

8/1/16

(2x)

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/08/16 (42)

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-122

Location:

PPP Rev:

8/1/16 SP

(2x)

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8/08/16 (2)

Job Completion



W 08-01-16

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2351	RE SHEET 1 S
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

*cut per drawing

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36602

RELEASED
05.11.28 #

UNDER REVIEW

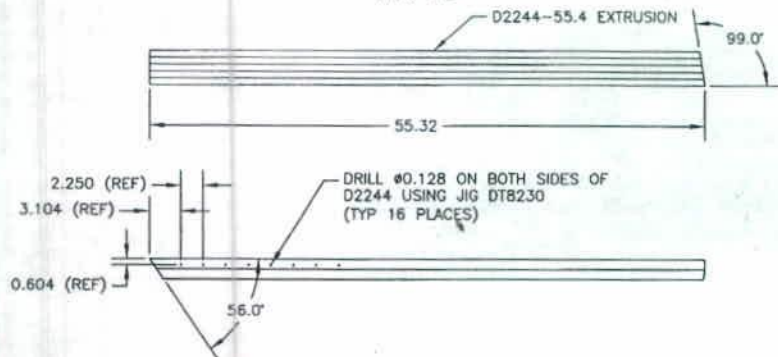
PH
07.01.07

07.11.24 #
PER PIC# 263

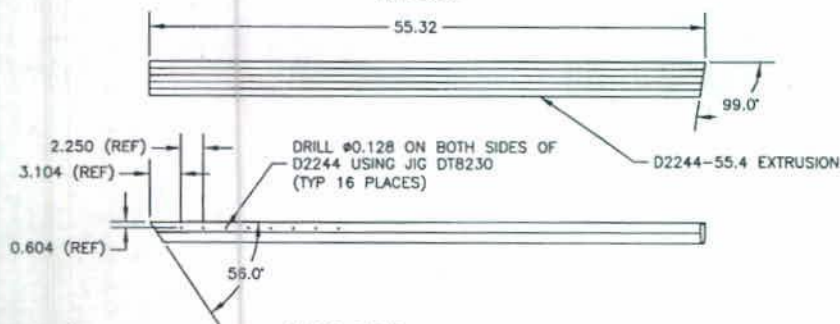
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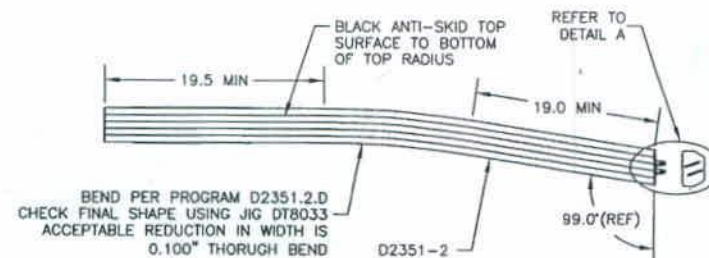
D2351-2 CUTTING/DRILLING DETAIL
RIGHT STEP



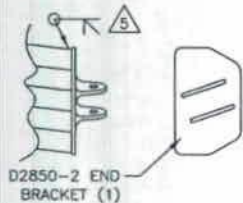
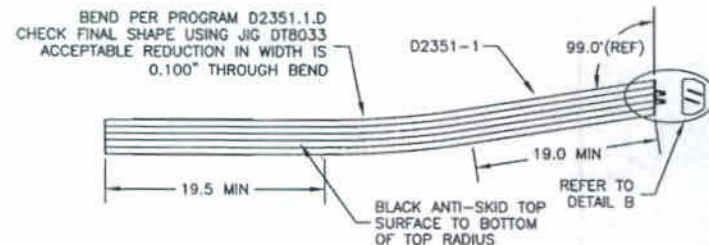
D2351-1 CUTTING/DRILLING DETAIL
LEFT STEP



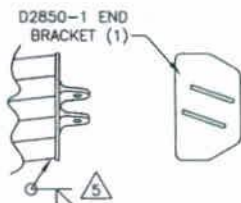
D2351-042 BENDING/ASSEMBLY DETAIL
RIGHT STEP



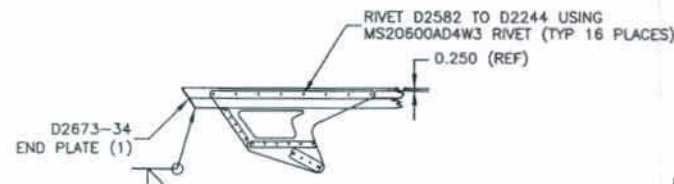
D2351-041 BENDING/ASSEMBLY DETAIL
LEFT STEP



DETAIL A
SCALE: 1:4



DETAIL B
SCALE: 1:4



GENERAL NOTES

- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CHAMFER D2244 EXTRUSION 0.075"x45° BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD.
KE	PH		HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2351	SHEET 2 OF 2
DATE		TITLE	SCALE
05.11.14		HIGH FLOAT STEP ASSEMBLY	1:12

RELEASED
05.11.28

UNDER REVIEW

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